

**Work Order ID 62215**

Page 1

Wednesday, September 22, 2010 11:46:55 A

Item ID: D3572-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *R*

Date: 10-9-22 Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank .500" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA685 Rev: <i>A/A</i> & Dwg D3572 Rev: <i>D</i> <input type="checkbox"/> 2-Debug per dwg D3572								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									

*SL 10/10/02**(10)**10 0**10/11/02**amf 10/11/02**10 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

**Work Order ID 62215**

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Wednesday, September 22, 2010 11:46:55 A

Item ID: D3572-3

Accept



Setup Start



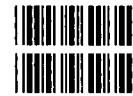
Revision ID:

Item Name: Guide

Stop



Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

QC8- Inspect parts - second check

0.00

M.A 10/11/02

10

Ø

Quality Control

140



Packaging

Identify as per dwg & Stock Location: 244

0.00

10/11/02 MF 10/11/02

Packaging

150



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

0.00

10/11/02 MF 10/11/02
MF  
10-11-2

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# Picklist Print

Wednesday, September 22, 2010 11:47:00 AM

Page 1

Work Order ID: 62215



Parent Item: D3572-3



Parent Item Name: Guide

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-07 JLM  
IPP rev B rev.B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased		No			f	42.5606	0.04	0.400200			

6061-T6 Bar .750 X 1.50



SL 18/10/28

Location	Loc Qty	Loc Code
MAT	2.5606	
114415	2.5606	
MAT028	40	
114968	20	
114993	20	41

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DART AEROSPACE LTD	Work Order:	62215
Description: Guide	Part Number:	D3572-3
Inspection Dwg: D3572      Rev: D		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	<i>Anil</i>	Audited by:	<i>J. A.</i>	Prototype Approval:	N/A
Date:	10/11/02	Date:	10/11/02	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.05.01	New Issue	KJ/JLM	
B	08.04.15	Dimensions updated per Dwg Rev. C	KJ/DD	
C	09.05.15	Dwg Rev updated	KJ	

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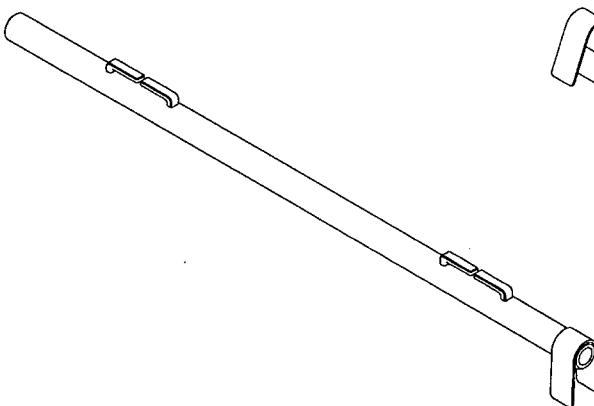
NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3		X		D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

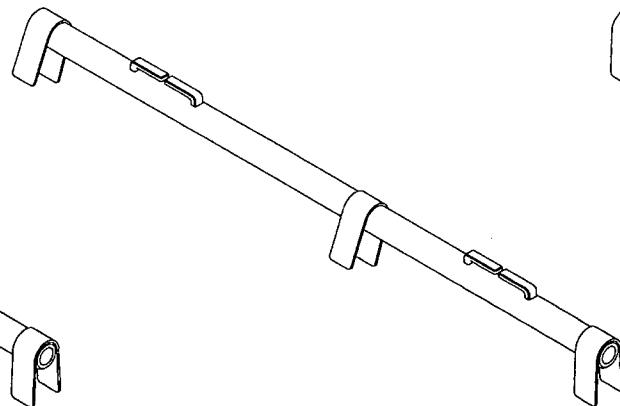
SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO.

62215  
B80922

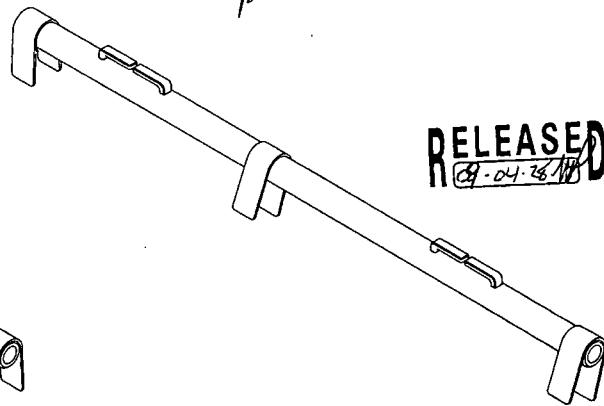
RELEASED  
04-26-08



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3572-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

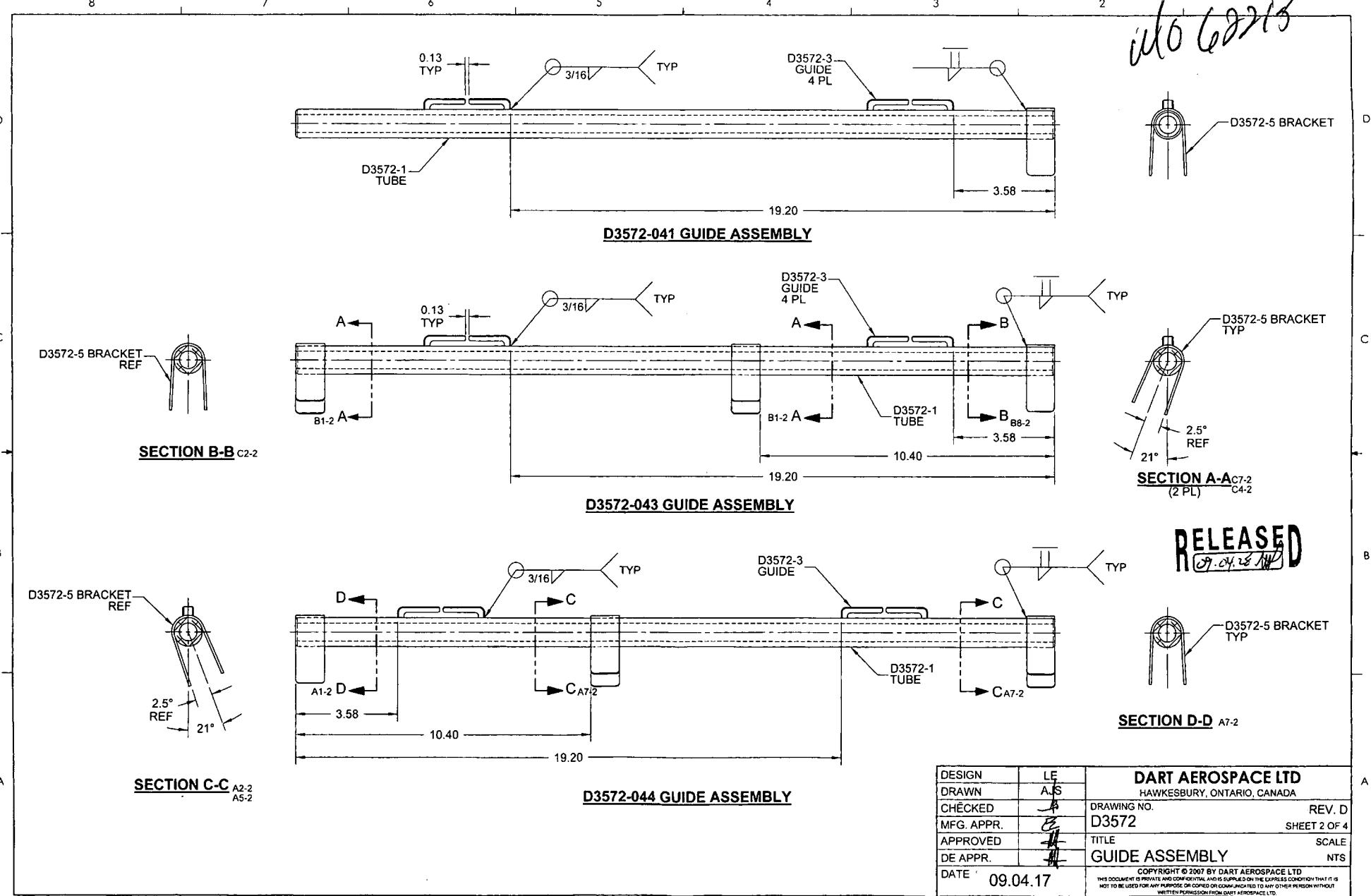
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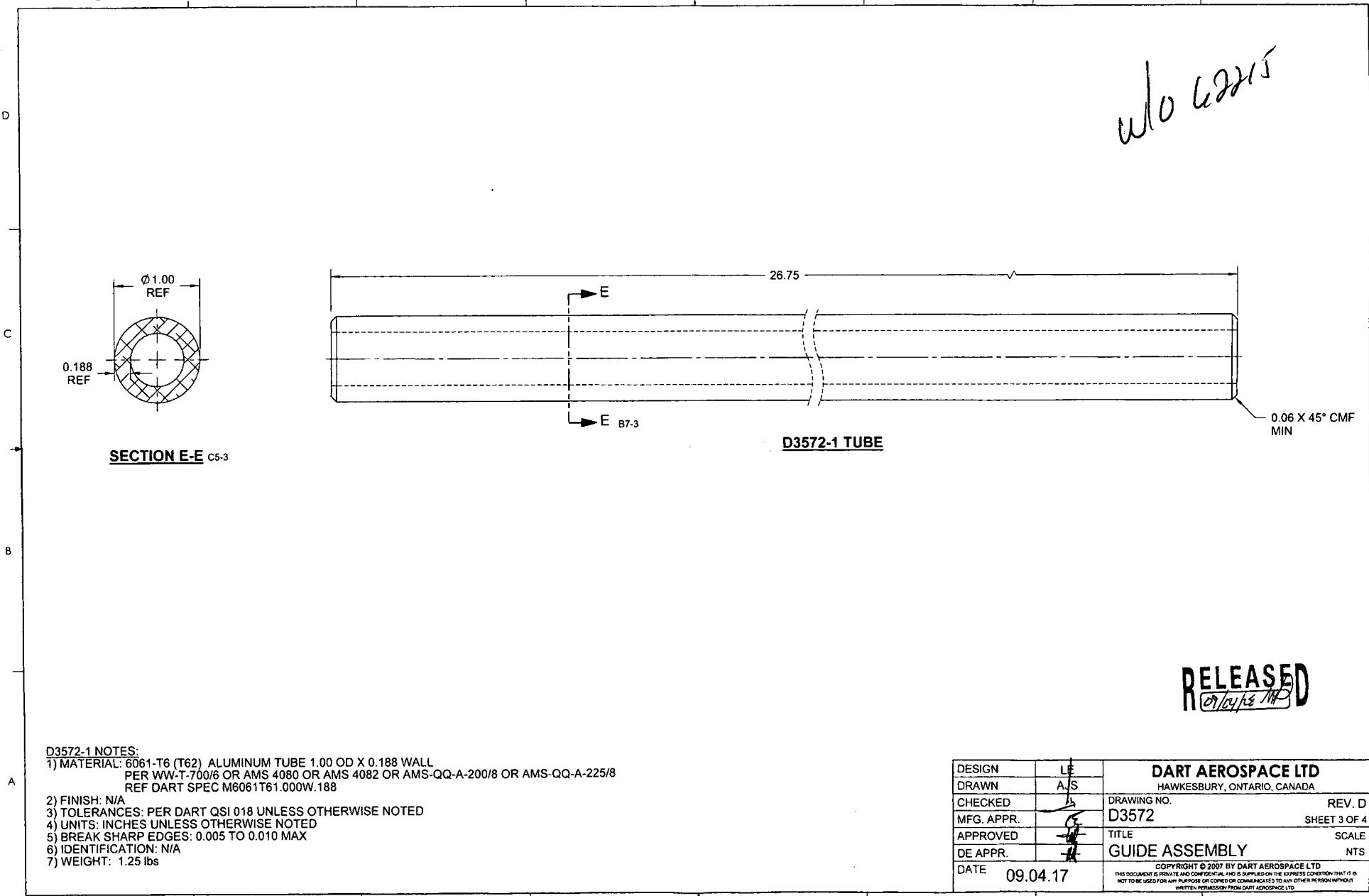
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

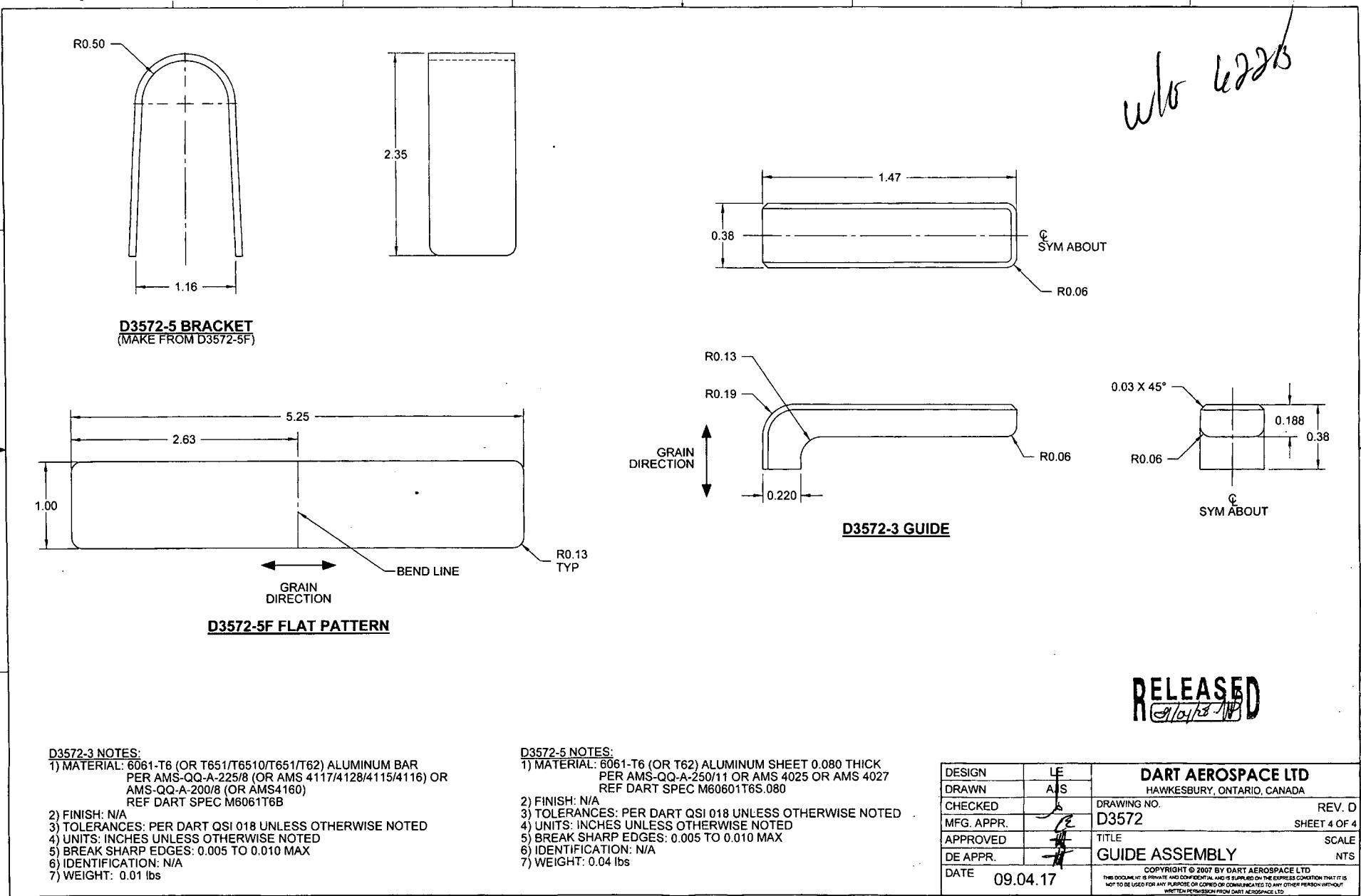
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